In the Specification:

Amend the paragraph at page 3, line 14 to read as follows:

The entire clamping device 1 is ~~rotateable~~ rotatable in directions which are represented by the arc φ. The position of the clamping device 1 with respect to the machine is continuously monitored by a position sensor 34 and signaled to an NC control unit as known in the art.

Amend the paragraph at page 3, line 30 to read as follows:

The clamping rings 5 visible in Fig. 1 comprise, according to Fig. 2, a first ring 5a and a second ring 5b. The ring 5a effects an adjustment of a first pair of opposed base jaws 16 associated with, for example, the vertical jaws in Fig. 1. The ring 5b effects the adjustment of a second pair of opposed jaws 16 associated with the horizontal jaws in Fig. 1. Both rings 5a and 5b are ~~rotateable~~ rotatable independently of each other and each have roller supports 13a, 13b, respectively, shifted against each other by an angle of 90°. Roller shaft bearers 14 with rollers 15 at one end are inserted in the roller supports 13a, b.

Amend the paragraph at page 4, line 3 to read as follows:

The outer rings of rollers 15 each bear against a pair of opposed cam or wedge surfaces 17 formed in each of the base jaws 16, and drive the base jaws radially inward or outward depending on the direction of rotation of the corresponding clamping ring. Each clamping ring has a pair of piston supports 22, located between the respective roller shaft bearers, which connect to an axially displaceable piston 25' in a piston cylinder 25. Preferably, as shown, the piston is a double piston. The pistons are secured to the piston supports by piston bolts 23 and standard securing rings 24 called "Seegerrings".

Amend the paragraph at page 4, line 16 to read as follows:

Fig. 3 shows the arrangement described above from the opposite side. Visible are the wedge surfaces 17 and the lateral grooves 19 in the base jaws 16. The rollers 15 can be seen as well between the embedded wedge surfaces ~~16~~ 17, as well as the screw connection 21 for the roller shaft bearers 14.

Amend the paragraph at page 4, line 31 to read as follows:

Depending on the profile to be clamped (workpiece/blank) the clamping jaws 6 are screwed onto the base jaws 16 with clearance against the profile. The positioning and maintenance of the clamping jaws 6 upon the corresponding base jaws 16 is facilitated by the base jaw toothing 18, the clamping jaws 6 having corresponding teeth. The hoses 3 are supplied with compressed air (controlled by the NC program) and the compressed air act on the pistons 25' (Fig. 2), closing the clamping unit, i.e. the clamping jaws 6 clamp the profile with a force of about 60 kg per jaw. The force transmission is easily seen; two opposing double pistons each move the ring 5a and/or 5b such that the rollers 15 roll on the wedge surfaces ~~16~~ 17 thereby moving the base jaws 16 radially in their lateral grooves 19 in respective grooves of the outer chuck body 29.